

# Work Order ID 57599

Friday, April 09, 2010 1:32:15 PM




Page 1

Item ID: D2506 Accept  Setup Start   
Revision ID: Stop   
Item Name: Label Plate  
Start Date: 4/12/2010 Start Qty: 5.00  Cust Item ID:  
Required Date: 4/15/2010 Req'd Qty: 5.00  Customer:  
Reference:

Approvals: Process Plan: MF Date: 10-4-9 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_


Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D2506	Rev F								


100  0.00  
Waterjet FLOW WATER JET  
Memo 0.00  
FLOW CNC Waterjet 1-Cut as per Dwg D2506 ☐ Dwg Rev: F ☐ Prog Rev: F ☐ 2-  
Deburr if necessary

10-4-12

5

110  0.00  
QC QC2- Inspect parts off machine FAI/FAIB  
Memo 0.00  
Quality Control

10-4-12

120  0.00  
QC QC8- Inspect parts - second check  
Memo 0.00  
Quality Control

8/10/09/12

25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Page 2

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Setup Start

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Brake NC Brake NC	NC BRAKE  Memo 1-Form as per dwg D2506	0.00  0.00	SA 10/04/12			(5)	0		
140  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00	Sub 10/04/13			(45)			
150  Packaging Packaging	Identify as per dwg & Stock Location: <u>WA</u>  Memo	0.00  0.00	SA 10-04-13			(5)			

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Page 3

Item ID: D2506

Accept



Setup Start



Revision ID:

Stop



Item Name: Label Plate

Start Date: 4/12/2010 Start Qty: 5.00



Cust Item ID:

Required Date: 4/15/2010 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/04/15

10-4-14  
(5)

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**Work Order ID:** 57599



**Parent Item:** D2506



**Parent Item Name:** Label Plate


**Start Date:** 4/12/2010

**Required Date:** 4/15/2010

**Comments:** IPP B 01.06.08 Now laser cut EC  
IPP C 06.12.13 ecn 822 ec  
IPP Rev:D 08-12-01 rev.F as per dwg DD verified by:

**Start Qty: 5.00**

**Required Qty: 5.00**

Component Item ID/ M304S20GA	Replacement	Mfg/ Purchased	Bin No	Primary	Last	Route 100	Unit of sf	Qty on 79.0000	Remaining 6.4211	Qty	Date	Status
<div>  <div>304/316 .040 Sheet</div> <div> <div>Warehouse</div> <div>Location</div> <div>Main Warehouse</div> <div>MAT20</div> <div>112885</div> <div>113062</div> </div> <div> <div>Loc Qty</div> <div>79</div> <div>15</div> <div>64</div> </div> <div> <div>Loc Code</div> <div></div> </div> </div> <div> <div>1810-4-12</div> <div>113062</div> </div>												

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<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	
<b>Description:</b> Label Plate		<b>Part Number:</b>	<b>D2506</b>
<b>Inspection Dwg:</b> D2506	<b>Rev:</b> F	<b>Page 1 of 1</b>	

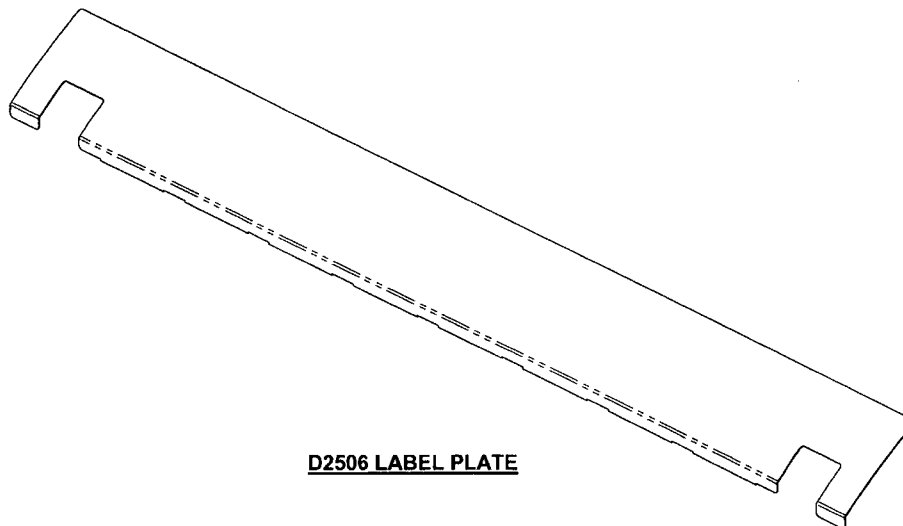
### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.50	+/-0.030	4.505	✓			
1.31	+/-0.030	1.313	✓			
1.88	+/-0.030	1.882	✓			
32.63	+/-0.030	32.63	✓			
39.00	+/-0.030	39.00	✓			
2.00	+/-0.030	1.997	✓			
0.063	+/-0.010	.064	✓			
1.00	+/-0.030	1.006	✓			
2.95	+/-0.030	2.948	✓			
0.040	+/-0.010	.036	✓			

<b>Measured by:</b> JB	<b>Audited by:</b> S	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 10-4-12	<b>Date:</b> 10/04/12	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	06.08.29	New Issue	KJ/JLM	
B	06.12.20	Dwg Rev. updated	KJ/JLM	
C	07.09.06	0.040 dimension added	KJ/JLM	
D	09.06.26	Dimensions update per Dwg Rev F	KJ	









# 57599

**D2506 LABEL PLATE**

**RELEASE**  
02/11/18 MIP

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.040 THICK  
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524 
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.92 lbs

F	REDRAWN IN SOLIDWORKS TO CURRENT STANDARD AND TRANSFERRED TO "B" SIZE FORMAT; UPDATED NOTE 1 (ZN A6-1); ADDED DETAIL A (ZN C8-2); 124" WAS 127" (ZN A4-2). REASONS: EASE MANUFACTURING WITH CORRECTION OF BEND AND ADDITION OF INTERMITTENT WELDING LOCATORS	MB	08.09.23
E	REMOVE 10" BEND; ADD NOTES; 127" WAS 126"	CB	06.11.20
D	32.63 WAS 32.25; 1.31 WAS 1.50	KE	99.10.04
C	RE-DESIGN OF LABEL PLATE	MM	96.09.04
B	RE-DESIGN OF LABEL PLATE	MM	96.06.18
A	NEW ISSUE	KH	95.11.26
REV.	DESCRIPTION	BY	DATE
DESIGN	BAW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D2506</b> TITLE <b>LABEL PLATE</b> <small>COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.09.23	REV. F	SHEET 1 OF 2
		SCALE	NTS

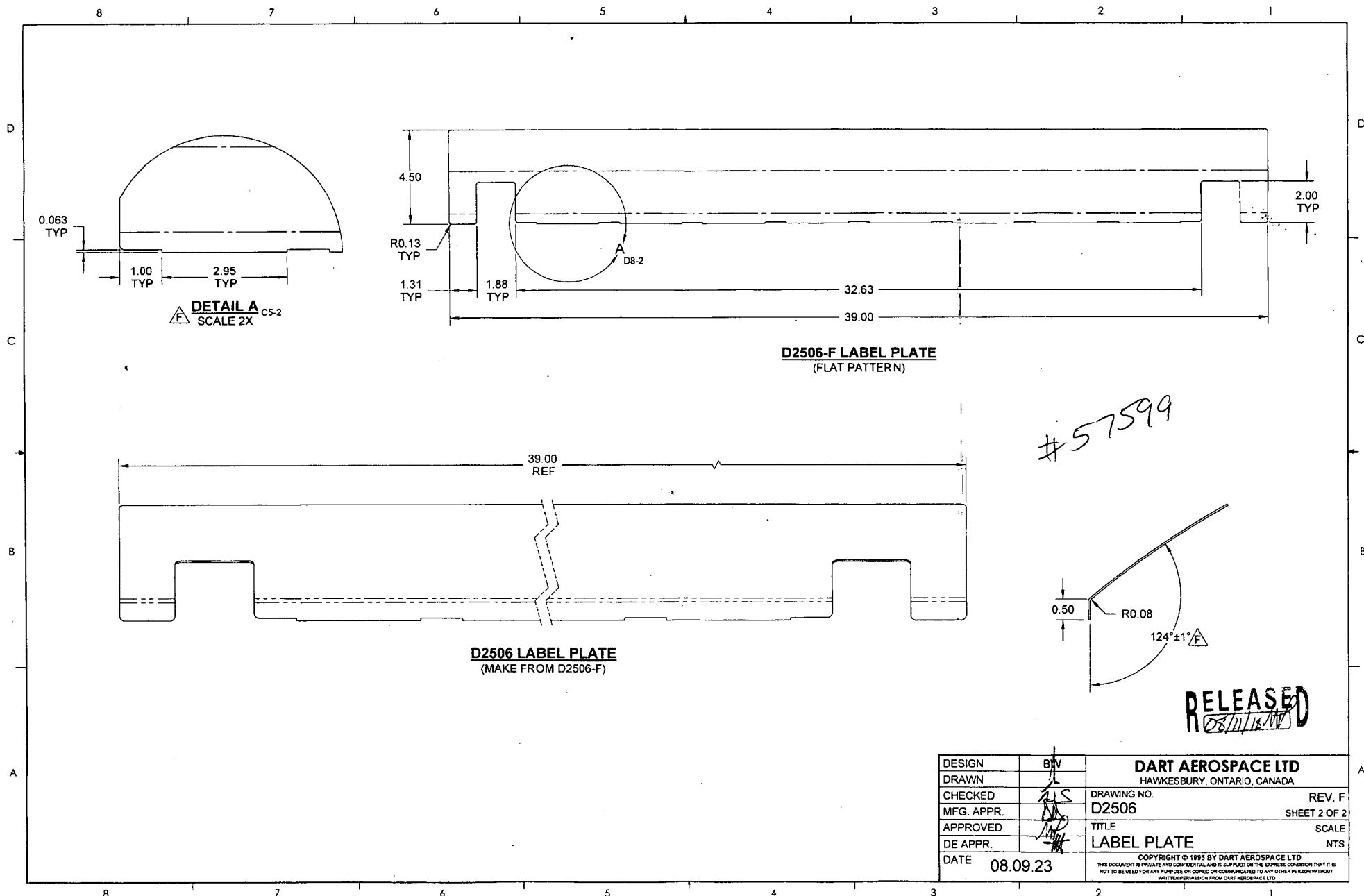
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DESIGN	BV	<b>DART AEROSPACE LTD</b>	
DRAWN	JS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JS	DRAWING NO.	REV. F
MFG. APPR.	JS	<b>D2506</b>	SHEET 2 OF 2
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	<b>LABEL PLATE</b>	NTS
DATE	08.09.23	<small>COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

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